

# Work Order ID 71509

Tuesday, July 05, 2011 10:17:11 AM



Page 1

Item ID: D3437-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Strut Assembly

Start Date: 7/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3437

Rev B

100

0.00



Small Fab

Small Fab

Memo

*B* 0.00

Small Fab

Assemble as per Dwg D3437Dwg Rev:

*EP 11/07/05 (4)*

110

0.00



QC- 100% Inspect kits for completeness

*as*

*Suloxloc*

QC

Memo

0.00

Quality Control

*(4)*

120

0.00



Identify as per dwg & Stock Location: *308*

Packaging

Memo

0.00

Packaging

*11/7/05 (4)*

**Work Order ID 71509**

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Tuesday, July 05, 2011 10:17:11 AM

Item ID: D3437-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Strut Assembly

Start Date: 7/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/06 [Signature]  
MF  
11-07-06

# Picklist Print

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Page 1

Work Order ID: 71509

Parent Item: D3437-043

Parent Item Name: Aft Strut Assembly



Start Date: 7/5/2011

Required Date: 7/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP AI 105.05.20 New Issue [KJ/JLM]

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C516  WASHER		Purchased	No			100	Each	39.0000	2	8			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST347	39						
						102842	39						
D3437-1  Foot		Manufactured	No			100	Each	11.0000	1	4			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST508	11						
						46046	11						
D3437-3  Clip		Manufactured	No			100	Each	37.0000	1	4			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST508	37						
						43175	37						
D3437-9  Eyebolt		Manufactured	No			100	Each	6.0000	1	4			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST508	6						
						44790	6						

*EP 11/07/05*

*EP 11/07/05*

*EP 11/07/05*

*EP 11/07/05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 71509

Parent Item: D3437-043

Parent Item Name: Aft Strut Assembly



Start Date: 7/5/2011

Required Date: 7/12/2011

Start Qty: 4.00

Required Qty: 4.00

MS21043-5

Purchased

No

100

Each

587.0000

1

4



Nut



*EPB 11/07/05*

Location

Loc Qty

Loc Code

FG	20	
101418	20	
ST301	467	
112314	367	
116548	100	
ST314	100	
118159	100	

_____
_____
_____
4
_____
_____
_____

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

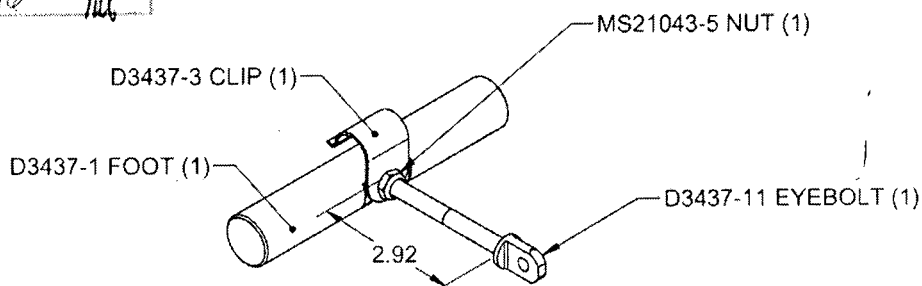
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

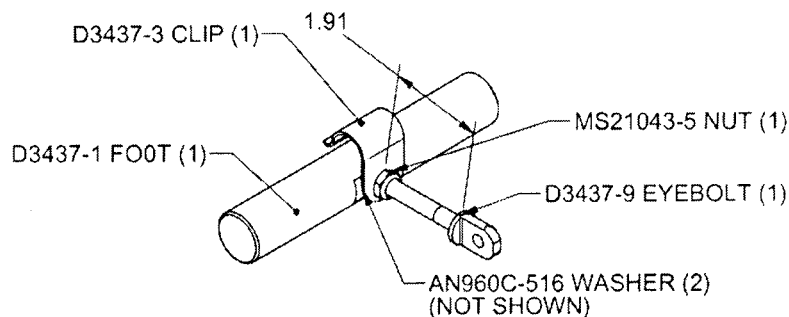


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3437</b>	REV. B SHEET 1 OF 4
DATE <b>05.08.11</b>		TITLE <b>AFT STRUT ASSEMBLY</b>	SCALE 1:2
A	05.04.29	NEW ISSUE	
B	05.08.11	UPDATE D3437-5/-9/-11 DIMENSIONS	

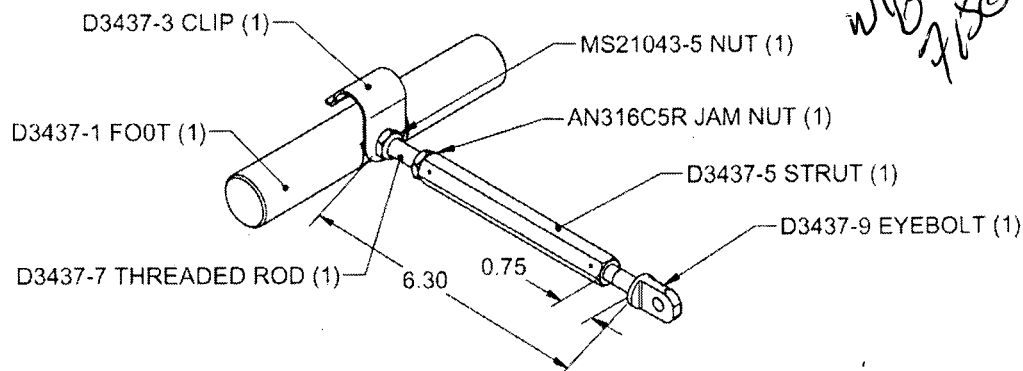
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05.08.11 *[Signature]*



#### D3437-041 AFT STRUT ASSEMBLY



#### D3437-043 AFT STRUT ASSEMBLY



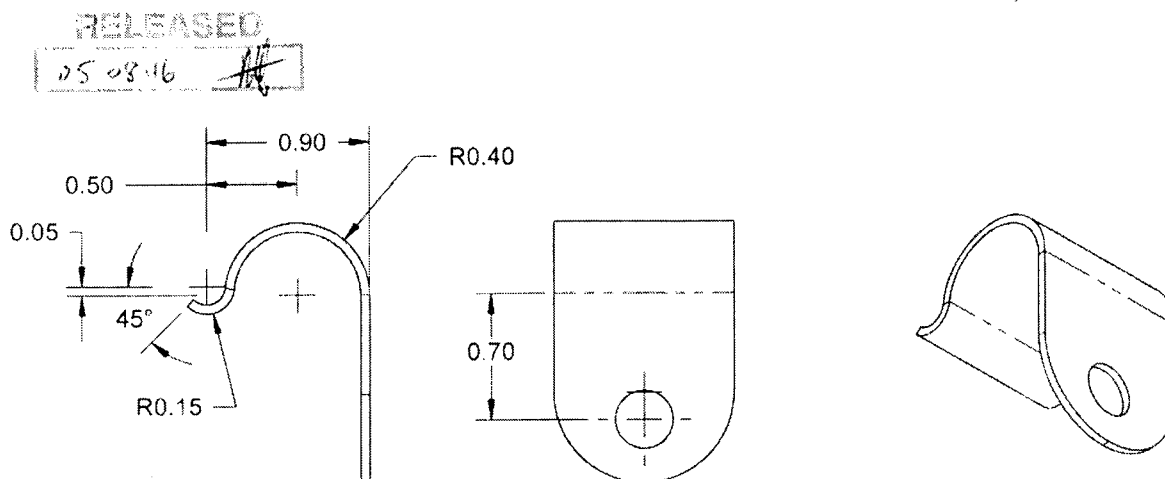
#### D3437-045 AFT STRUT ASSEMBLY

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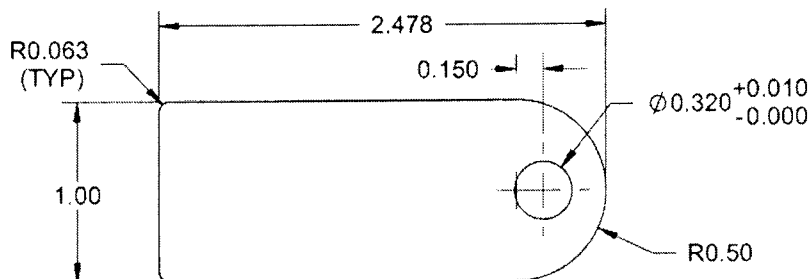
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 2 OF 4
DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2



**D3437-3 CLIP**  
SCALE 1:1



**D3437-3**  
**FLAT PATTERN**

**D3437-3 CLIP:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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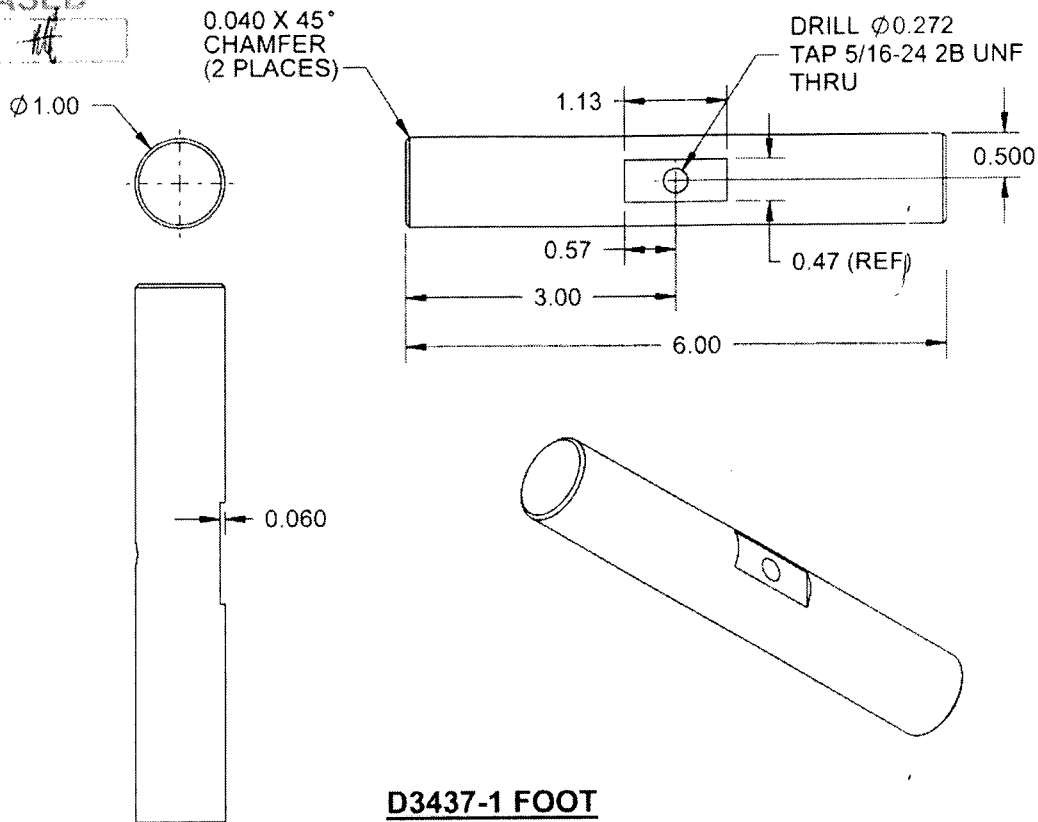




DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3437</b>	REV. B SHEET 3 OF 4
DATE <b>05.08.11</b>	TITLE <b>AFT STRUT ASSEMBLY</b>		SCALE 1:2

RELEASED

05-08-11 *[Signature]*

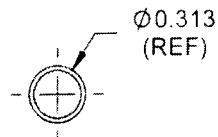
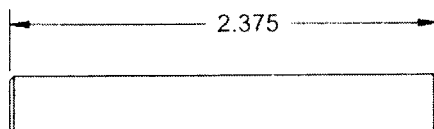


**D3437-1 FOOT**

**D3437-1 FOOT:**

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR (REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

21509



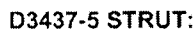
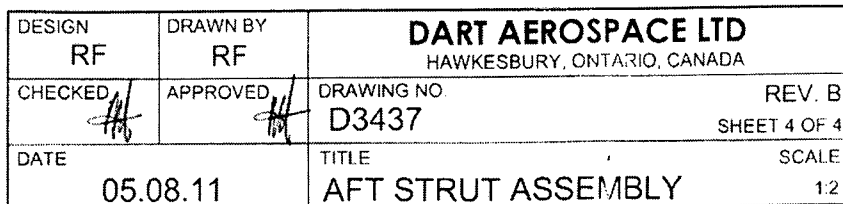
**D3437-7 THREADED ROD**

**D3437-7 THREADED ROD:**

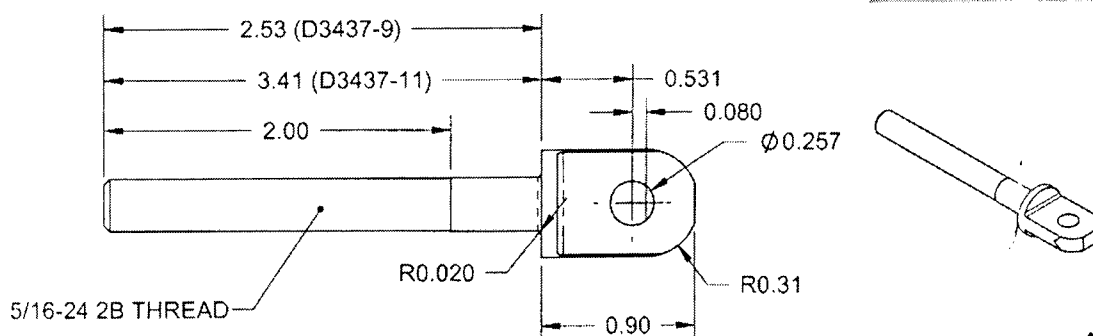
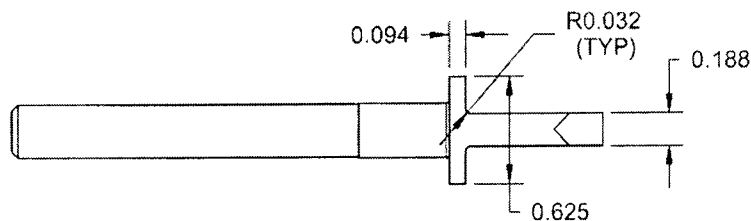
- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAU P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)  
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010



**D3437-9/-11 EYEBOLT:**

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)  
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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